

Work Order ID 54790

December 22, 2009 9:50:40 AM



Page 1

Item ID: D3655-3

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 1/05/10 Start Qty: 3.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: 

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3655

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

BB
10/04/06
(X3)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT
898511 Dwg. Rev. B Folio Rev. A

BB
10/01/06
(X3)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB
10/01/06
X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54790

December 22, 2009 9:50:40 AM

Page 2

Item ID: D3655-3

Accept

Setup Start

Revision ID:

Stop

Item Name: PANEL

Start Date: 1/05/10 Start Qty: 3.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 3.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

OK 10/01/06 (X3)

140

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3655

BB 10/01/06 (X3)

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

BB 10/01/06 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54790

December 22, 2009 9:50:45 AM

Page 3

Item ID: D3655-3

Accept

Revision ID:

Item Name: PANEL

Start Date: 1/05/10

Start Qty: 3.00

Required Date: 1/15/10

Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/15



QC

Memo

0.00

Quality Control

(x3)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-1-18 (34) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/18

mf
10-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 9:50:37 AM

Page 1

Work Order ID: 54790



Parent Item: D3655-3



Parent Item Name: PANEL

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	103.9800			
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GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

749.8926526

107574

16.62

111973

190.526053

112176

542.7466

10/01/05 x3
BB.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 31790
Description: Panel		Part Number: D3655-3
Inspection Dwg: D3655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 10/01/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9	+/-0.100	67.875	✓			
25.0	+/-0.100	25.	✓			
44.5	+/-0.100	44.5	✓			
0.070	Min	.087	✓			
0.050	Min	.054	✓			

Measured by: JB

Date: 10/01/14

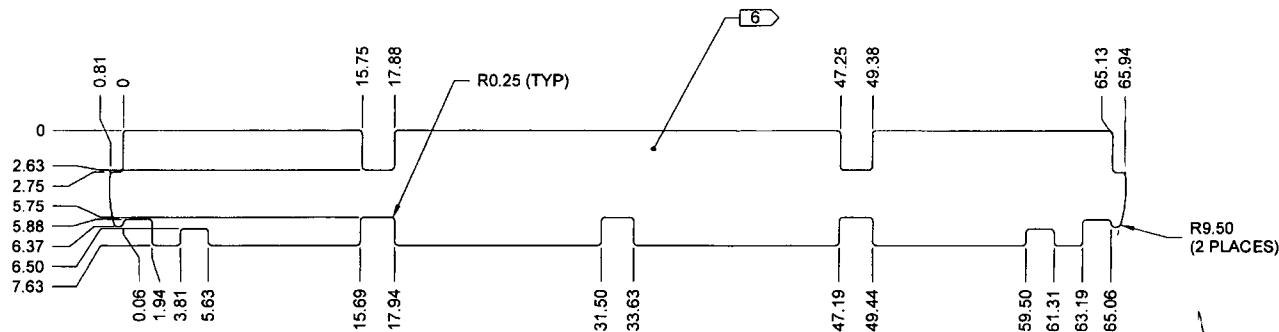
Audited by: AK

Date: 10/01/14

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	<u>M</u>



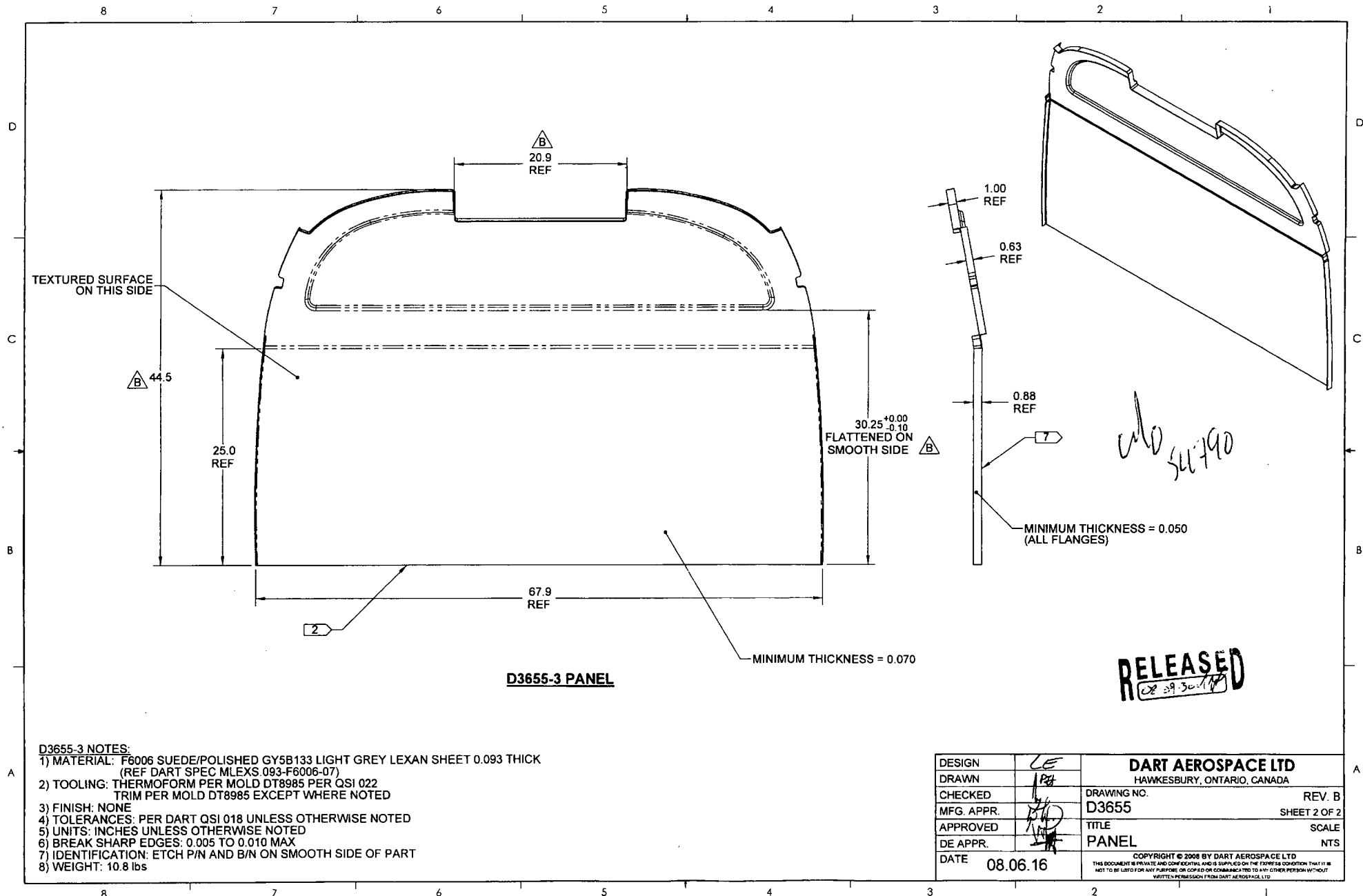
D3655-1 PANEL

RELEASED
08.07.30/14

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	08.06.16		
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		REV. B	SHEET 1 OF 2
		SCALE	NTS



DESIGN	LE	DART AEROSPACE LTD	
DRAWN	PR	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PR	DRAWING NO.	REV. B
MFG. APPR.	PR	D3655	SHEET 2 OF 2
APPROVED	PR	TITLE	SCALE
DE APPR.	PR	PANEL	NTS
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